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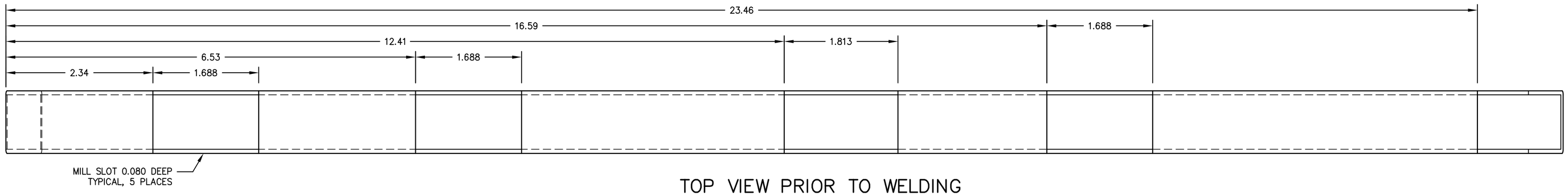
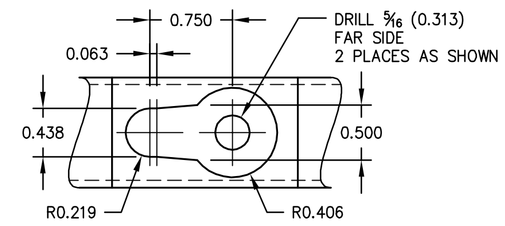
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE – CREATED FROM 78632	BJC	APR 01/10
1	TITLE BLOCK UPDATED; PADS (ITEM 11, 12) ADDED; ALTERNATE FINISH	BJC	14/07/2014
	CAP (ITEM 04) MATERIAL CHANGED; SLOT DEPTH INCREASED		
2	SECOND WELD ADDED TO GUIDE TUBE	BJC	06/01/2016

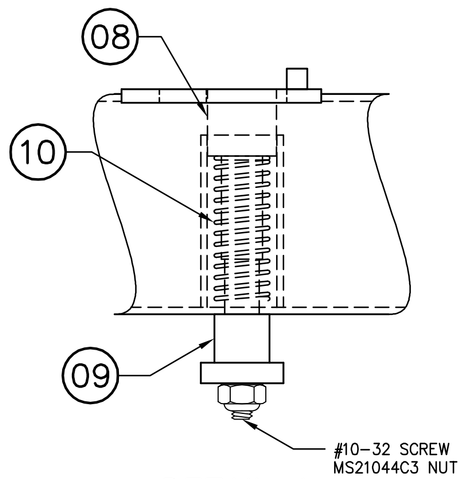


TOP VIEW PRIOR TO WELDING



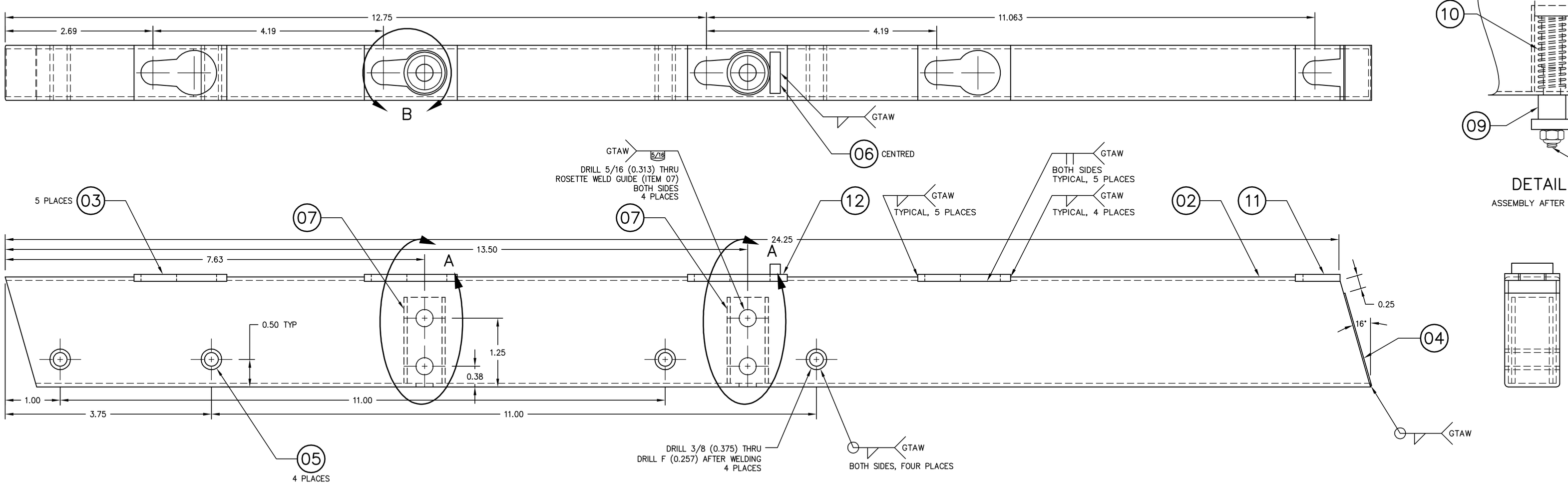
DETAIL B

TYPICAL, ALL KEYWAYS



DETAIL A

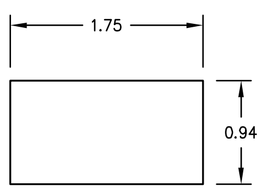
ASSEMBLY AFTER FINISHING



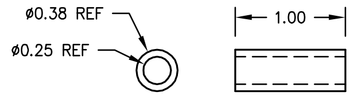
01 78634-01-00 BEAM ASSEMBLY

11 PAD

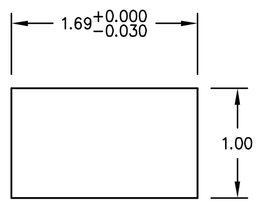
12 PAD



04 CAP



05 BUSHING



03 PAD

01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	78634-12	12	PAD	304 STAINLESS STEEL	ASTM A240	1.0 X 0.125 BAR
1	78634-11	11	PAD	304 STAINLESS STEEL	ASTM A240	1.0 X 0.125 BAR
2	MS21044C3		NUT			
2	#10-32		C'SUNK SCREW	STAINLESS STEEL	COMMERCIAL	
2	69830-23	10	SPRING	STAINLESS STEEL	COMMERCIAL	15mm X 70mm SPRING
2	69830-22	09	KNOB	6061-T6 ALUMINUM	QQ-A-200/8	ø0.75 ROD
2	69830-21	08	STOP	6061-T6 ALUMINUM	QQ-A-200/8	ø0.625 ROD
2	69830-11	07	GUIDE	304 STAINLESS STEEL	ASTM A269	ø0.75 X 0.065 RND. TUBE
1	69830-07	06	BLOCK	304 STAINLESS STEEL	ASTM A479	0.188 SQR. ROD
4	78630-04	05	BUSHING	304 STAINLESS STEEL	ASTM A269	ø0.375 X 0.065 RND. TUBE
1	78634-04	04	CAP	304 STAINLESS STEEL	AMS 5513	0.050 SHEET
3	78634-03	03	PAD	304 STAINLESS STEEL	ASTM A240	1.0 X 0.125 BAR
1	78634-02	02	TUBE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.065 TUBE
	78634-01-00	01	BEAM ASSEMBLY			
QTY	LIST OF MATERIALS					

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 304 STAINLESS STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
3. FINISH: ALL STEEL PARTS TO BE THOROUGHLY DEGREASED AND POWDER COATED PRIOR TO ASSEMBLY. ALTERNATE: ALL STEEL PARTS TO BE THOROUGHLY DEGREASED, PRIMED AND PAINTED PRIOR TO ASSEMBLY.

APPROVALS		DATE
DRAWN:	JEFF CLARKE	01 APR 2010
CHECKED:	E. BURGOIN	06 JUN 2010

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:

DECIMALS		ANGLES
X.XXX	±0.010	±1/2°
X.XX	±0.03	
X.X	±0.1	

AERO DESIGN LTD.
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AIRBUS HELICOPTERS AS350 & AS355 SERIES
ATTACHMENT PROVISION
FORWARD BEAM FABRICATION

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A1	78634	2